

Work Order ID 140196

140196

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Thursday, December 17, 2015 3:44:09 PM

Item ID: D350-615-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GHW Modification, Fits LH or RH

Start Date: 12/7/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: HLS Date: JAN 04 2016

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-615-041

B

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003DAS
28
9-89

JAN 08 2016

110

0.00

110

Small Fab

Small Fab

Memo

0.01

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***DAS
36
9-89

16/01/06

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

DAS
38
9-89

JAN 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140196

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Item ID: D350-615-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: GHW Modification, Fits LH or RH
Start Date: 12/7/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.00				6	DAS 28 9-89		JAN 08 2016
Quality Control									
140		0.00							
140									
Packaging	Memo	0.00				6x	DAS 28 9-89		JAN 08 2016
Packaging	Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPH D350-615-041 Location :FG023								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.01				MCS			JAN 08 2016
Quality Control									

MCS JAN 08 2016

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 140196

140196

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 12/7/2015

Required Date: 12/17/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041		Manufactured	No			110	Each	7.0000	1	6			
D2282-041									**			16/01/06	DAS 36 9-89
T Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				7					
				137286				1					
				139046				6					
D2282-043		Manufactured	No			110	Each	0.0000	1	6			
D2282-043									**			16/01/06	DAS 36 9-89
Saddle Assembly													
5/16-18-015C		Purchased	No			110	Each	122.0000	3	18			
5/16-18-015C									**			16/01/06	DAS 36 9-89
SS Bolt 5/16-181.5"K													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st572				122					
				m133171				122					
D3015-3		Manufactured	No			110	Each	51.0000	3	18			
D3015-3									**			16/01/06	DAS 36 9-89
Locknut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				18					
				95758				8					
				96151				10					
				ST015				33					
				136803				33					

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		OTHER : ☐							